

ABSTRACT

A patterned roller including one or more patterned rings  
5 forming an overall cylindrical pattern. The patterned roller  
may also include one or more spacer rings to form grooves or  
channels into a surface. The patterned roller may be included  
in a roller stack as part of a manufacturing system for  
patterned film. The patterned roller can include a pattern to  
10 form full corner cubes of many different sizes and/or geometries  
in a continuous manner across the width and along the length of  
a reflective sheet without seams. Methods of manufacture  
include rolling the cylindrical pattern of the patterned roller  
into a surface of an extruded sheet. Articles are manufactured  
15 utilizing the methods of manufacture including license plates,  
shoes, highway signs, articles of clothing, pavement markers,  
automobile reflectors, and bicycle reflectors.